

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013065**Date Inspected:** 13-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

This QA Inspector Randomly observed the following work in progress:

BAY-1- Traveler Rail (TR)

Flux Cored Arc Welding (FCAW) welding of Repair weld joint 20TR1-039-005. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW welding of Repair weld joint 20TR2-018-011. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

BAY-2-Floor Beam (FB)

Submerged Arc Welding (SAW) welding of weld joint FB3200-001-025. Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint FB3200-001-026. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint FB3188-001-010. Welder is identified as 045203. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2a-F-1.

BAY-5-TR

FCAW welding of Repair weld joint 10TR1-029-014. Welder is identified as 203710. ZPMC Quality Control (QC) is identified as Mr. Sheng jian gao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1. The Repair welding was been performed against the Welding Repair Report (WRR) No: B-WR11849 Rev No: 0 and ZPMC Ultrasonic Testing (UT) Report No: B787-UT-12144R1.

BAY-7-TR

This QA Inspector observed ZPMC welding personnel performing Buttering by FCAW process for 10TR2-004. Welder is identified as 062447. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e. WPS-345-FCAW-1G (1F)-Repair-1. The Buttering welding was been performed against the B-CWR1100 Rev No: 0 and ZPMC Quality Control (QC) is identified as Mr. Cui jun jie and Certified Welding Inspector (CWI) is identified as Mr. Liu fa wen.

This QA Inspector observed ZPMC welding personnel performing Buttering by FCAW process for 10TR1-009. Welder is identified as 048625. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e. WPS-345-FCAW-1G (1F)-Repair-1. The Buttering welding was been performed against the B-CWR1100 Rev No: 0 and ZPMC Quality Control (QC) is identified as Mr. Cui jun jie and Certified Welding Inspector (CWI) is identified as Mr. Liu fa wen.

BAY-6-WEST JACKING FRAME (WJF)

SMAW welding of weld joint WJF-0-419. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Zhang sheng jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3312-1.

During Quality Assurance Random in process Visual Inspection (VT) review of welds located on Orthotropic Box Girder (OBG) West Jacking Frame WJF-0-187, this Quality Assurance Inspector (QA) discovered the following issue:

- One (1) Longitudinal Linear Crack observed on the tack weld measuring approximately 20 mm in length.
- The weld is identified as: WJF-0-187.
- According to ZPMC QC they will remove the tack weld and perform Magnetic Particle Testing (MT) prior to

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

welding.

- The attached photographs provide additional detail.

This QA notified ZPMC QC identified as Mr. Zhao jian Hang and AB/F QA Inspector identified as Mr. Wang wen bin of the above issue, and reported to the Team leader.

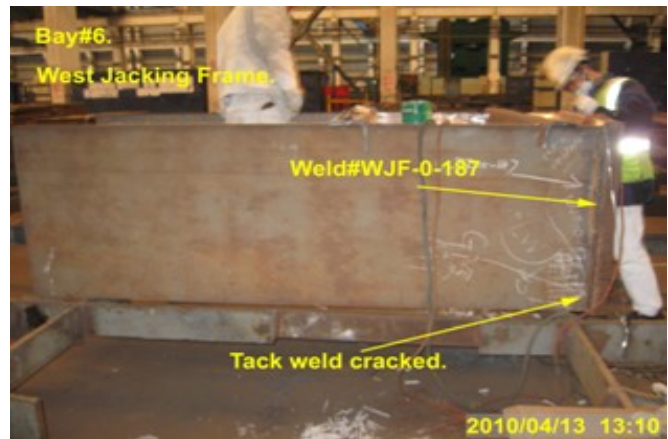
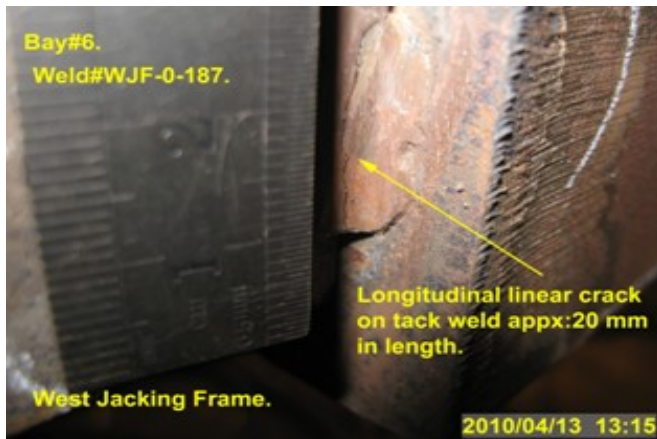
Applicable reference:

AWS D1.5 2002 figure 6.8 – specifies for fillet weld sizes between 6mm and 13mm the maximum discontinuity length is approximately 2mm to 4mm.

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks”.

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
